

FIG. 3

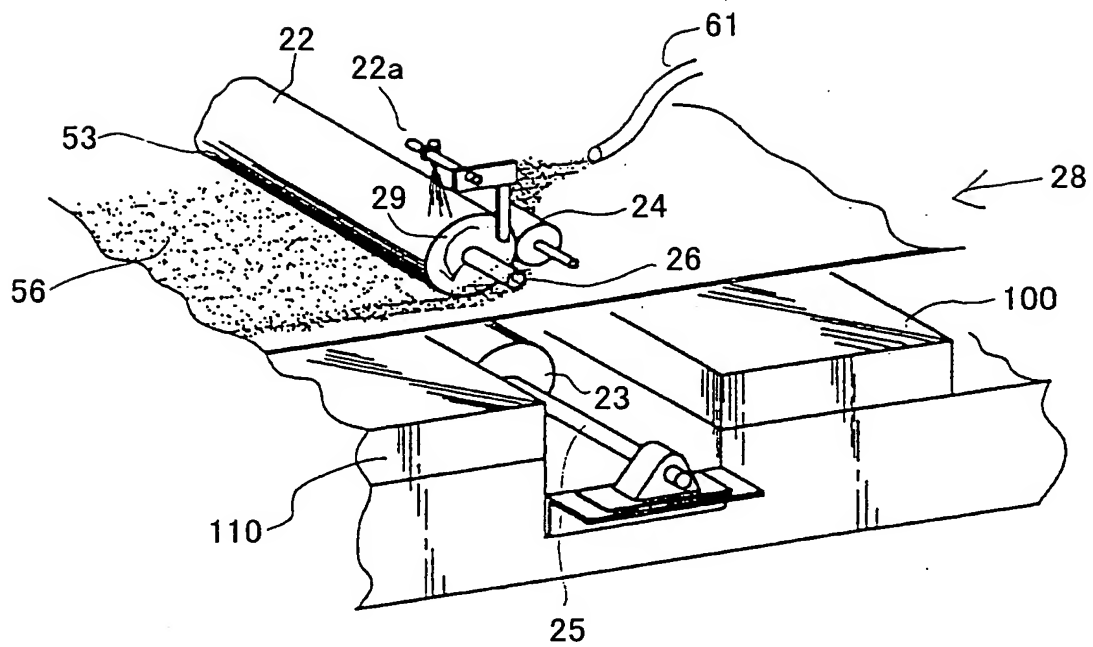


FIG.4

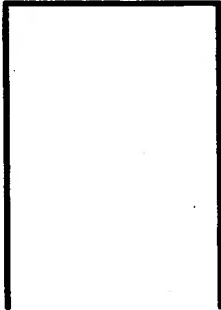
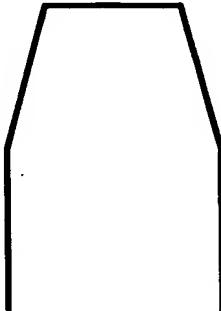
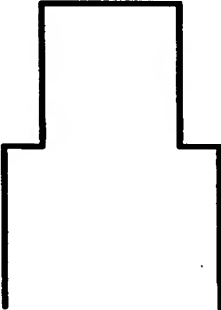
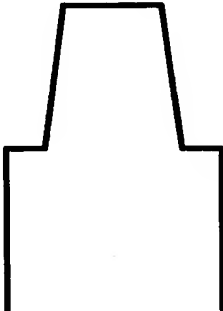
END SHAPE OF SPREADER ROLL			
(a) SQUARE		(c) FORWARD TAPER	
(b) STEP		(d) STEP+ FORWARD TAPER	

FIG.5

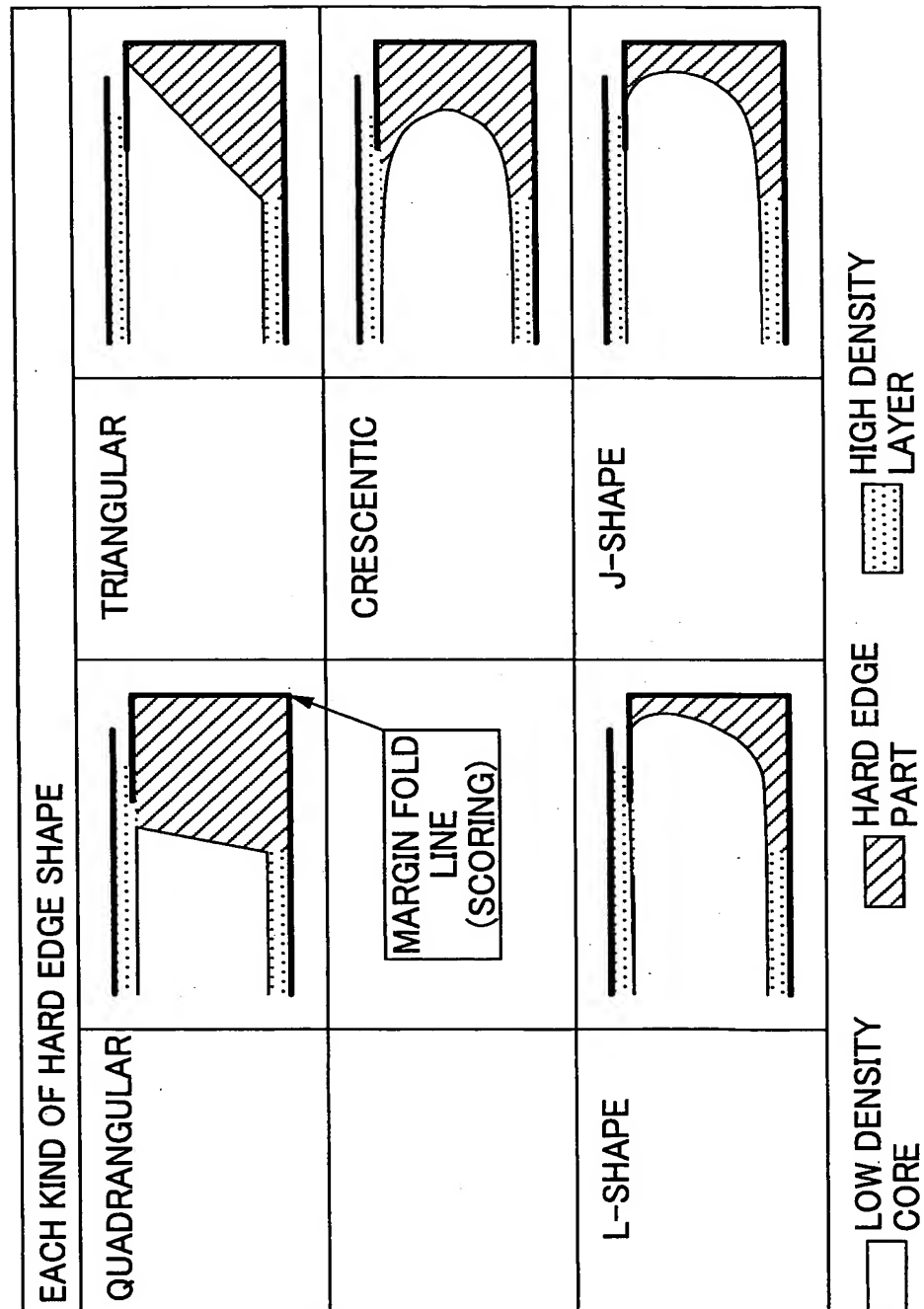


FIG. 6

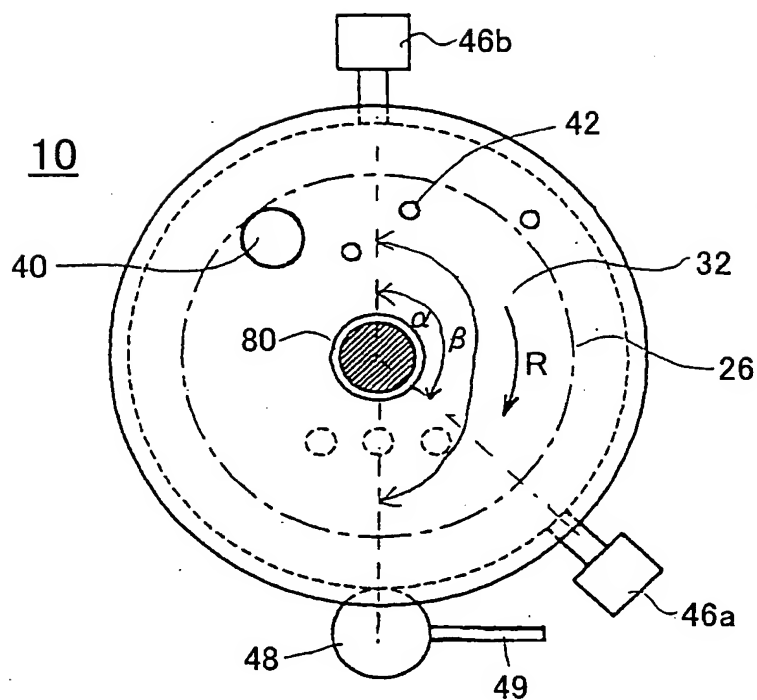


FIG. 7

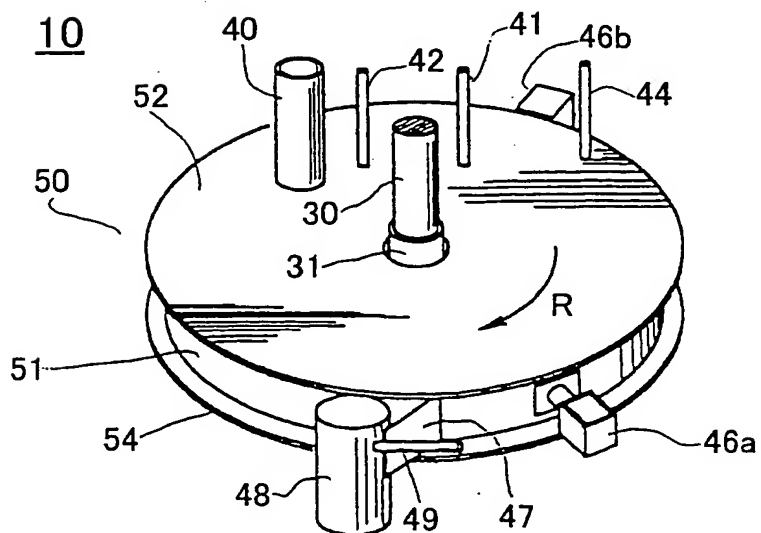


FIG. 8

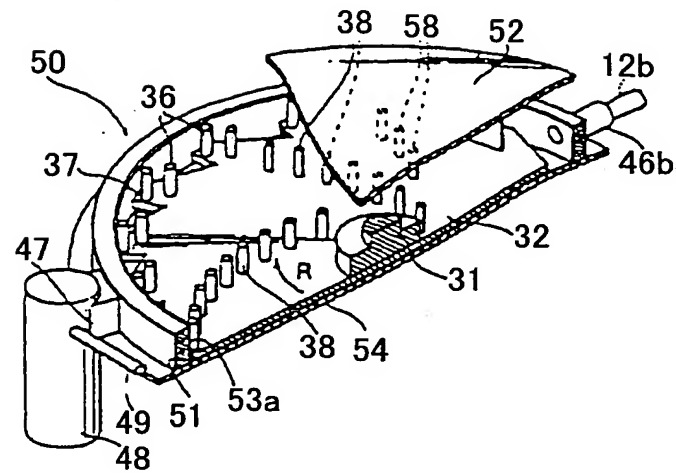


FIG. 9

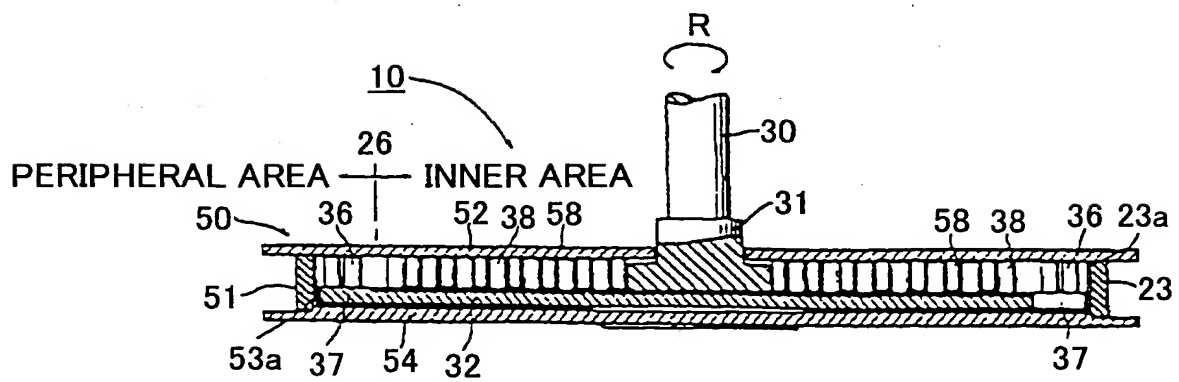


FIG.10

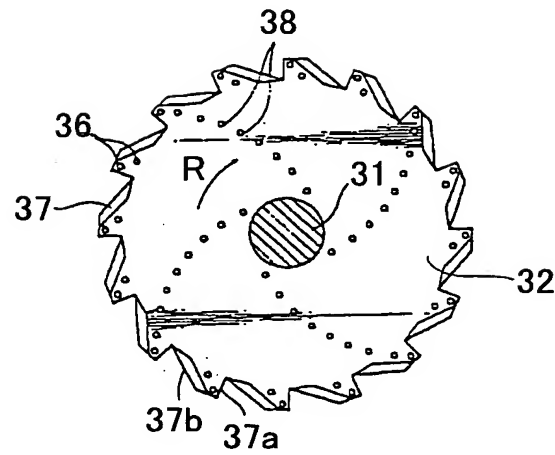
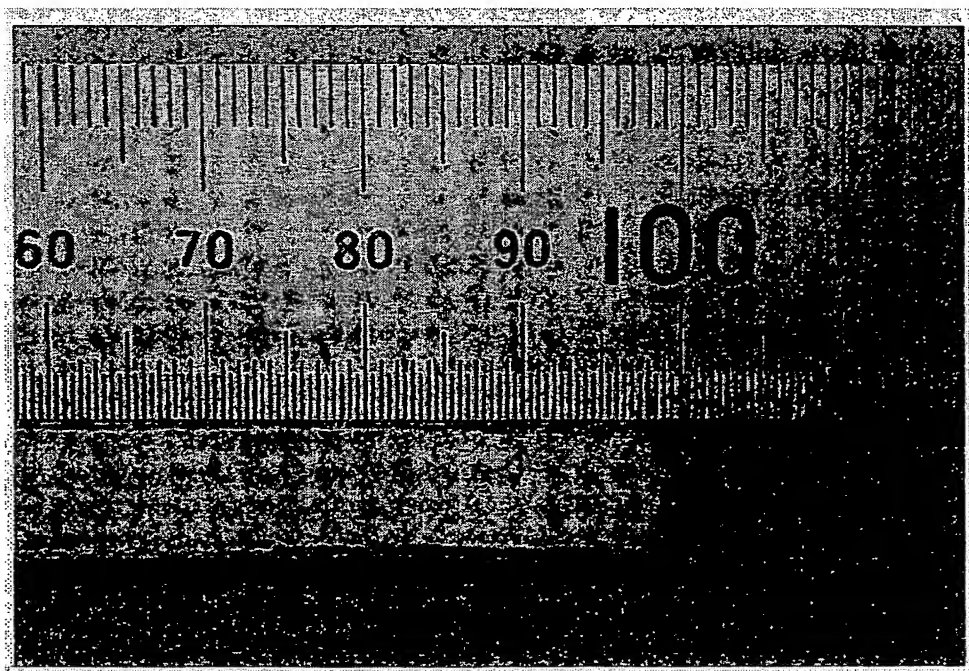


FIG.13



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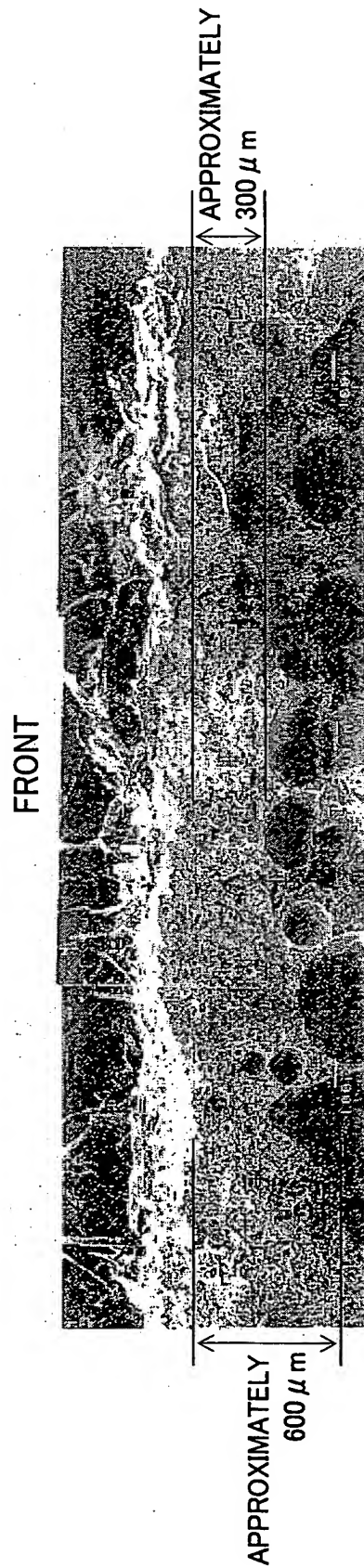
FIG.11A

SAMPLE	DENSITY OF HIGH DENSITY LAYER (g/cm ³)		AVERAGE THICKNESS OF HIGH DENSITY LAYER (μ m)		DENSITY OF CENTRAL LAYER (g/cm ³)	HARD EDGE				
	FRONT SURFACE SIDE	BACK SURFACE SIDE	FRONT SURFACE SIDE	BACK SURFACE SIDE		DENSITY (g/cm ³)	SHAPE (L/J)	MAXIMUM THICKNESS IN WIDTH DIRECTIONS (mm)	MINIMUM THICKNESS IN WIDTH DIRECTIONS (mm)	MINIMUM THICKNESS OF PAPER ADHERED PART (mm)
EXAMPLE 1	0.95	0.95	500	500	0.65	0.95	L	12.5	4.2	3.1
EXAMPLE 2	0.95	0.95	500	500	0.65	0.95	J	10.2	3.5	2.2
EXAMPLE 3	0.95	0.95	500	500	0.66	0.95	J	7.6	2.8	1.5
EXAMPLE 4	0.80	0.80	500	500	0.67	0.80	J	9.8	3.0	2.5
EXAMPLE 5	1.05	1.05	300	300	0.64	1.05	J	4.4	0.5	0.2
COMPARISON 1	0.99	0.96	100	150	0.67	-	-	-	-	-
COMPARISON 2	1.10	1.06	100	150	0.69	0.73	TRAPEZOID	55.0	40.0	12.0
COMPARISON 3	0.95	0.95	500	500	0.68	0.95	TRAPEZOID	30.0	20.5	11.9

FIG.11B

SAMPLE	BASE PAPER ADHESION PROPERTY		DRY OUT (DECKLE EDGE ADHESION)		BOARD PROPERTIES			NAILING PROPERTY
	FRONT SURFACE SIDE	BACK SURFACE SIDE	RIGHT EDGE PART	LEFT EDGE PART	NAIL PULLING OUT RESISTANCE (N)	FLEXURAL STRENGTH- LOMGITUDINAL (N)	FLEXURAL STRENGTH- WIDTH DIRECTIONS (N)	
EXAMPLE 1	○	○	○	○	360	550	229	○
EXAMPLE 2	○	○	○	○	359	551	230	○
EXAMPLE 3	○	○	○	○	361	547	228	○
EXAMPLE 4	○	○	○	○	358	557	231	○
EXAMPLE 5	○	○	○	○	370	580	240	○
COMPARISON 1	○	○	×	×	362	560	220	○
COMPARISON 2	○	○	○	○	369	570	235	×
COMPARISON 3	○	○	○	○	363	520	221	×

FIG.12



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